

Work Order ID 162505

Tuesday, June 06, 2017 4:57:34 PM

162505

Page 1

Item ID: D3219-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 6/12/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 30.00 ***30*** Customer:

Reference:

Approvals: Process Plan:  Date: **20170607** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3219	B								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.43							
FLOW CNC Waterjet	1-Cut as per Dwg D3219								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.30							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.60							
Quality Control									

DAS
38
9-89
JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Page 363

Monday, June 05, 2017 4:53:59 PM

Work Order ID: 162505

162505

Parent Item: D3219-3

D3219-3

Parent Item Name: Plate

Start Date: 6/12/2017

Required Date: 6/15/2017

Start Qty: 30.00

Required Qty: 30.00

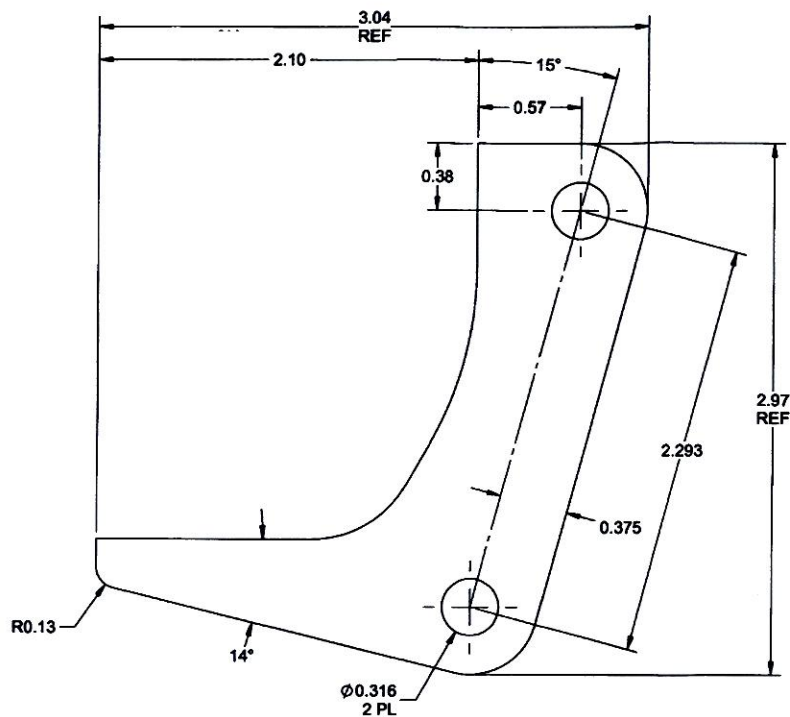
Comments: IPP REV:A 15.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	63.4570	0.063	1.989474			
M6061T6S 125									**				
6061-T6 .125 Sheet													

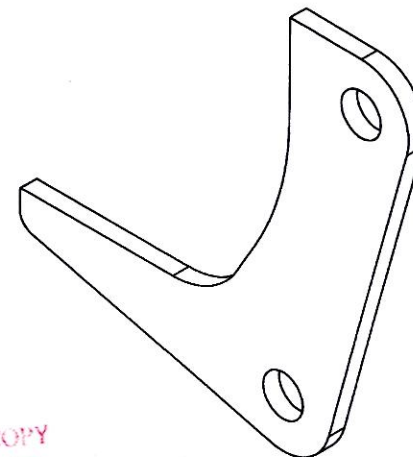
06/17/2017

Location	Loc Qty	Loc Code
MAT019	59.06	
m136896	34.3	
m137515	24.76	
MAT020	4.397	
m136327	4.397	

2.4



D3219-1 PLATE



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162505
GA 20170601

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125 THICK
PER: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE D3219-1-REV B.DXF

RELEASED
2016-03-14
Ecnb-656

APPROVED

B	REDRAWN TO CURRENT STANDARDS. ADD -3 & -5. REF CIR15-44.	AJS	15.11.27
A	NEW ISSUE	CP	03.10.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3219	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PLATE	NTS
DATE	15.11.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

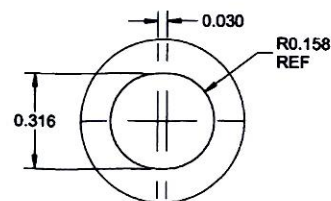
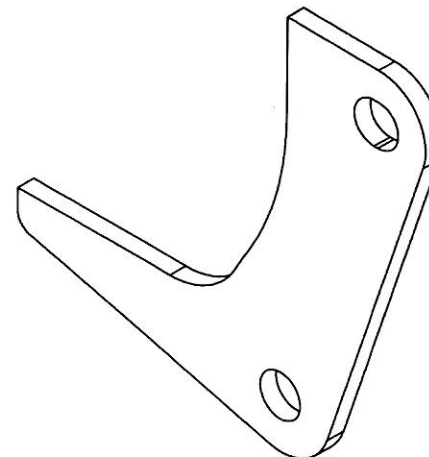
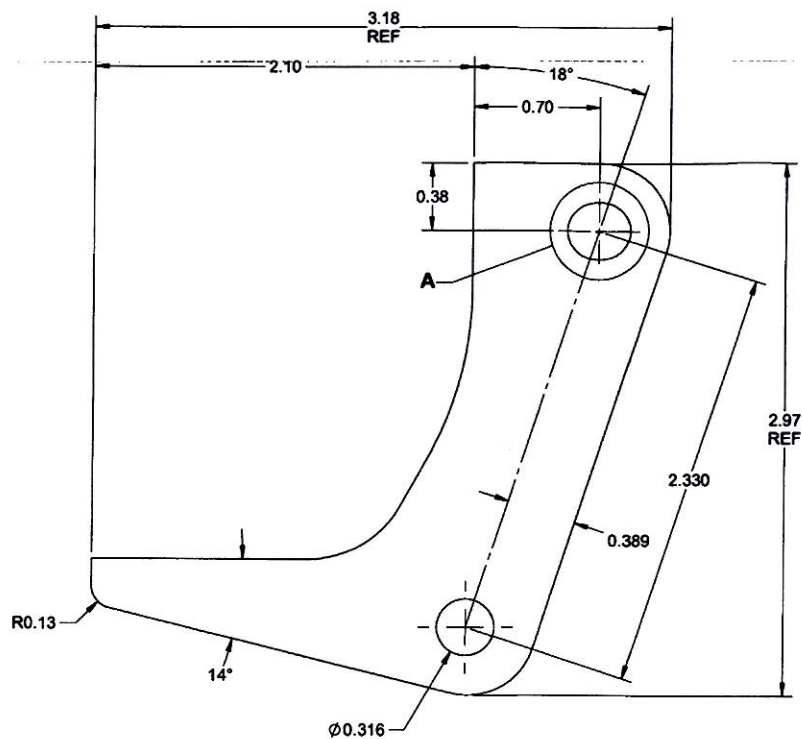
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



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DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3219	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PLATE	NTS
DATE	15.11.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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OTHER : ☐									